	Vork Order ID 67604 Sonday, March 28, 2011 2:28:06 PM										Page 1
Revision ID:	D3547-1			Accept					Setup St	1 (881118	
		Start Qty: 6.00 Req'd Qty: 6.00		(1) AW	Cust Item I Customer:	D:				1 1 1 1 1 1 1 1	
Approvals:	Process Plan	:	Date:	Tooling: SPC (Y/N):		nte:		I			
Sequence ID/ Work Center ID		Operation Description	-	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp
Draw Nbr	Revis	sion Nbr									
D3547	Rev A	4									
Waterjet FLOW CNC Waterjet	t _.			0.00 0.00 wg Rev:			,	BII-	<u>3-31</u>	(L	
QC Quality Control		QC2- Inspect parts off n Memo		0.00 0.00	essary			KB1	1-33		
120 QC Quality Control		QC8- Inspect parts - sec Memo	ond check	0.00 u (3)	131			(414)			

W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					1						
······											
•											
					_						
Part No		PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ/	A:	Date:			
	Res	solution:	Disposition);	QA: N/C Closed: Date:						
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)					
DATE	STEP	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector		
		g = 100									
			· .	-							
								1			
							,				

Work Order ID 67604

Monday, March 28, 2011 2:28:06 PM



Page 2

Item ID:

D3547-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Bracket

3/28/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Tooling: Date:

Date:

Run

Start



Required Date: 3/31/2011

QC:

Date:_____

SPC (Y/N):

Tool ID

Date: ___

Tool # Plan

Code

Stop

Reject

Oty

Number Stamp

Insp.

Reject

Sequence ID/

Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Bend as per Dwg D3557

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00

0.00

Sis Moula

140

QC

Quality Control

Memo

Chemical Conversion Coat per QSI005 4.1

Accept

Qty

150

HandFinish

Memo

0.00

0.00

JH BK 11-4-11

Hand Finishing

Dart Aerospac	ce	Ltd
---------------	----	-----

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE ·		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	egory:	NCI	NCR: Yes No DQA: Date:						
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:	Date: _				
NCR:		. V	VORK ORD	ER NON-CONFO	RMANCE	(NCR						
DATE	STEP	Description of NC	Corrective Action Sec			Cian 8	Verification		Approval			
	VIL	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section C	Chief Eng	QC Inspector			
		,							a			
					يور .							
		·							*•.			
						-						
				e e								
	1						*					

Work Order ID 67604

Monday, March 28, 2011 2:28:06 PM



Page 3

Item ID:

D3547-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Bracket

3/28/2011

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Required Date: 3/31/2011

QC:

Date:

SPC (Y/N):

Set Up/

Tool ID

Date:

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Identify as per dwg & Stock Location:

M16964

Run Hours 0.00

0.00

OYEN TEMPERATURE:

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

14 B Sel 104/12

14 Bel 11-4-13

I 80

Packaging Packaging

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	ANGE	.	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:	Fault Cat	egory:	_ NCR:	Yes N	lo DQ A	\:	Date:			
		esolution:										
NCR:		***************************************	WORK ORE	DER NON-CONFORM	ANCE (NCR)						
		Description of NC	Corrective Action Section				Verific	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng			Sign & Se		n C	Chief Eng	QC Inspector		
		·										

Work Order ID 67604 Monday, March 28, 2011 2:28:06 PM				Page 4				
Item ID: Revision ID:	D3547-1			Accept	1	Setup		
Item Name: Start Date: Required Date	Bracket 3/28/2011 e: 3/31/2011	Start Qty: 6.00 Req'd Qty: 6.00	 		Cust Item ID: Customer:		Stop	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run	Start Stop	

Work Center ID

Sequence ID/

QC

Quality Control

Description

Operation

QC21- Final Inspection - Work Order Release

Memo

S 1 1 1

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

Dart	Aero	spa	ce	Ltd

Dart Ae	rospace L	td						* *,
W/O:			WORK ORDER	CHANGES		_		
DATE	STEP	PR	OCEDURE CHANGE	. E	By Dat	te Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	•	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date: _	
	Resc	olution:	Disposition:	QA: N	/C Closed	•	Date: _	
NCR:		,	WORK ORDER NON-CON	FORMANCE (I	NCR)			
DATE	CTED	Description of NC	Corrective Action	on Section B	v	erification	Approval	Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval Chief Eng	Approval QC Inspector					
DATE	STEP	Section A			Sign & Date			Section C				
				1,								
		-										

Picklist Print

Monday, March 28, 2011 2:28:12 PM

Work Order ID: 67604

Parent Item: D3547-1

Parent Item Name: Bracket



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No				sf	154.0000		0.334737	,2		
										B	11 -3 -	31	

6061-T6 .125 Sheet

<u>Location</u>	Loc Oty	Loc Code	
MAT021	154		75
113608	130	113608)	(19
116700	24		\mathbf{O}

Page 1

W/O:		***************************************	iES	<u> </u>					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								<u> </u>	
•									
Part No	-	PAR #:	Fault Cate	gory:	_ NCR: Yes	s No [DQA:	Date: _	
	R	esolution:	Disposition	1:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B Initial Action Description			rification	Approval	Approval
	O L	Section A	Chief Eng	Action Description Chief Eng	Sign Dat		Section C	Chief Eng	QC Inspector
	i,								

DART AEROSPACE LTD	Work Order:	1,11,04		
Description: Bracket	Part Number:	D3547-1		
Inspection Dwg: D3547 Rev: A		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/-0.010	,311	k		V BO2	
0.913	+/-0.010	,915	*		V	
2.054	+/-0.010	2,653	×		ν	
2.38	+/-0.030	7.381	*		V	
0.438	+/-0.010	,436	0		V	
2.813	+/-0.010	2,8(0	4		V	
0.575	+/-0.010	-576	Þ		V	
1.100	+/-0.010	1.098	Ø		V	
1.625	+/-0.010	760,1	*		ν	
2.150	+/-0.010	3,148	X		V	
2.675	+/-0.010	2,677	K		V	
3.25	+/-0.030	3.761	7		V	
Ø0.172	+0.005/-0.001	,175	*		J	
Ø0.323	+0.006/-0.001	,375	16	1	V	
0.125	+/-0.010	.134	Þ		V	

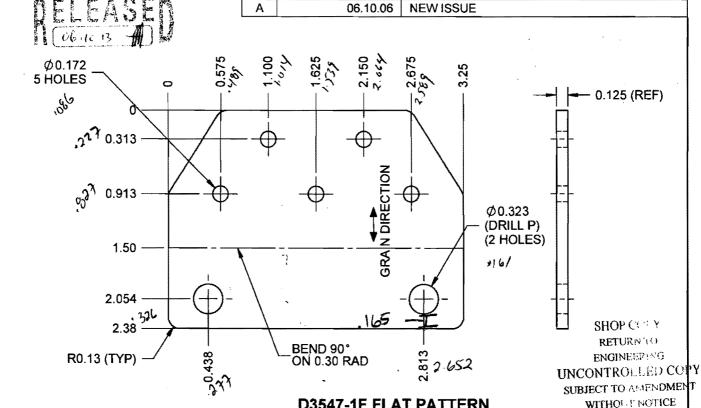
Measured by:	限	Audited by:	8	Prototype Approval:	N/A
Date:	11-3-31	Date:	4163/31	Date:	N/A

Rev	Date	Change	Revised by∧	Approved
Α	07.03.21	New Issue	KJ/JLM	B

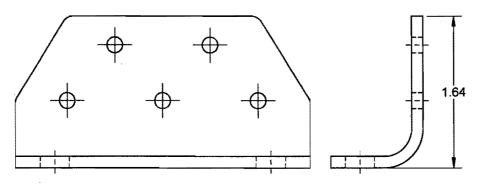
W/O:	•			VORK ORDER CHANG	GES		,			
DATE	STEP	PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
Part No		PAR #:	Fault Ca	tegory:	NCF	R: Yes	No DQA:		Date:	
	Res	olution:	Disposit	ion:	QA:	N/C CIG	osed:		Date:	
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR)			
D.47F	STED Description of NC		Corrective Action Section B			Sign & Verificati		tion	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section		Chief Eng	QC Inspector
										,
					100					
								-		



DESIG	Ņ	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	ED PH	APPROVED	DRAWING NO. D3547	REV. A SHEET 1 OF 1			
DATE	08.1	//\\ 0 06	TITLE BRACKET	SCALE			
06.10.06 REV DATE				1:1 RIPTION			







D3547-1 BRACKET

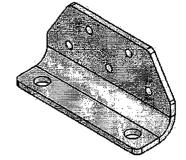
1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER



WORK ORDER

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

			•										
W/O:			WORK ORDER CHANGES										
DATE	STEP	PR	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
									•				
										A			
Part No	:	PAR #:	Fault Cate	jory:	NCF	l: Yes I	No DQ	A:	_ Date: _				
Resolution:		Disposition: Q			N/C Clo	sed:	Date:						
NCR:			WORK ORDE	ER NON-CONFOR	MANCE	(NCR))						
DATE	CTED	STEP Description of NC Section A			Section B	<u> </u>	Verification	Approval	Approval				
DATE	SIEP		Initial Chief Eng	Action Descriptio Chief Eng	on	Sign & Section C	on C	Chief Eng	QC Inspector				
		· · · · · · · · · · · · · · · · · · ·											
		*											